Date:

Friday, 10/12/2007 1:11:50 PM

User:

Chantal Lavoie

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**  : 35154

: 11467

P.O. Number This Issue

: NA

S.O. No. : MA : 10/12/2007

Prsht Rev.

First Issue : 34375 **Previous Run** 

: MA

: SMALL /MED FAB

Type

Part Number **Drawing Number** 

**Drawing Name** 

: D314095 : D3140 REV F

: DOUBLER

Project Number Drawing Revision

: N/A

Material **Due Date**  : 10/19/2007

Written By

Checked & Approved By

Comment

A02.04.30 New Issue NG

Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:D As per ECN #829 06-11-20 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

2024-T3 .032 sheet

1.0

M2024T3S032

1.5490 0.4646 sf(s)

Comment: Qty.: 0.1549 sf(s)/Unit Total: 2024-T3 .032 sheet

Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick

( M2024T3S.032 ) 6.40" x 3.81" flat pattern ref.

Batch M 105555 1807-10-1

2.0

SHEAR



Comment: SHEAR

Cut as per dwg D3140

WATER SE

SHEAR

1707-1015

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1







1-Scuff surfaces with 80grit sandpaper per QSI 006 3- Band as per Dug 03140

13

2-Deburr.

No sharp edges



4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Page 1

Form: rprocess

## **Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES   |  |      |     |                                     |                          |  |  |
|------|------|----------------------|--|------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | TEP PROCEDURE CHANGE |  | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
|      |      |                      |  |      |     |                                     |                          |  |  |
|      |      |                      |  |      |     |                                     |                          |  |  |
|      |      |                      |  |      |     |                                     |                          |  |  |
| ·    |      |                      |  | ···· |     |                                     |                          |  |  |

| Part No: | PAR #: | Fault Category: _ | NCR: Yes No | DQA:   | Date: Moll |
|----------|--------|-------------------|-------------|--------|------------|
|          |        |                   | QA: N/C C   | losed: | Date:      |

| NCR: |      |                   | WORK ORD             | ER NON-CONFORMANO            | CE (NCR)       |                           |                       |                          |  |  |  |
|------|------|-------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|--|--|
|      |      | Description of NC |                      | Corrective Action Section B  |                |                           |                       |                          |  |  |  |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |
|      |      |                   |                      |                              | J              |                           |                       |                          |  |  |  |

NOTE: Date & initial all entries

Friday, 10/12/2007 1:11:50 PM Date: User: Chantal Lavoie **Process Sheet** Drawing Name: DOUBLER Customer: CU-DAR001 Dart Helicopters Services Job Number: 35154 Part Number: D314095 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 5.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion ٠, (

Form: rprocess

Page 2

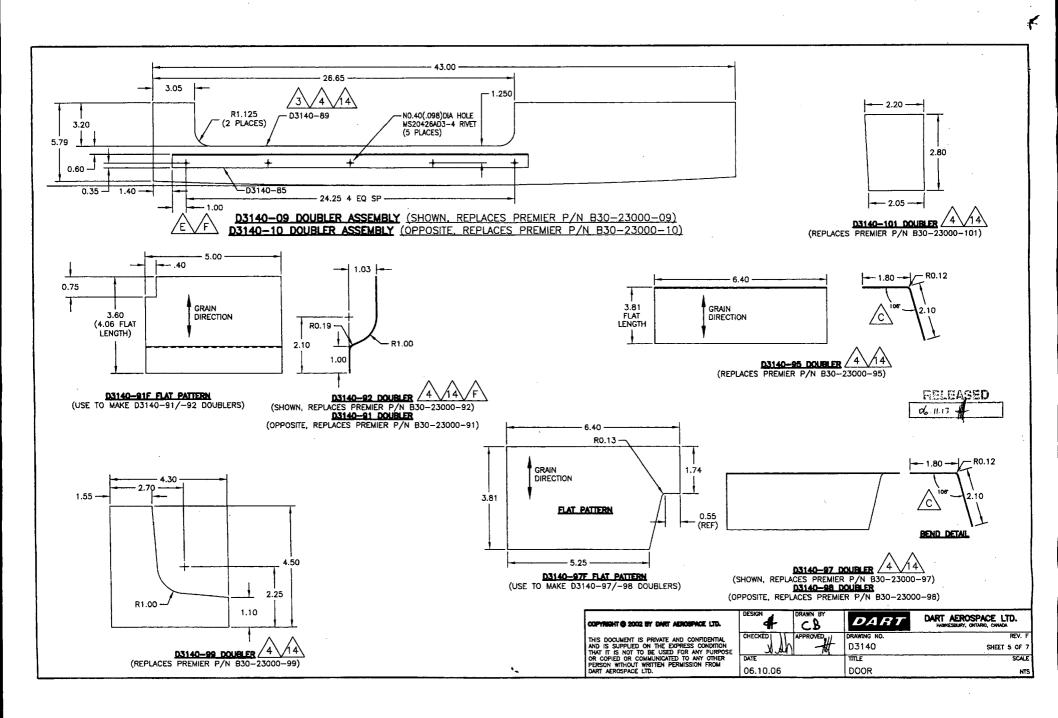
## **Dart Aerospace Ltd**

| W/O:    |      | WORK ORDER CHANGE      | WORK ORDER CHANGES |       |     |                                     |                          |  |  |  |
|---------|------|------------------------|--------------------|-------|-----|-------------------------------------|--------------------------|--|--|--|
| DATE    | STEP | PROCEDURE CHANGE       | Ву                 | Date  | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |  |
|         |      |                        |                    |       |     |                                     |                          |  |  |  |
|         |      |                        |                    |       |     |                                     |                          |  |  |  |
|         |      |                        |                    |       |     |                                     |                          |  |  |  |
|         |      |                        |                    |       |     |                                     |                          |  |  |  |
| Part No |      | PAR #: Fault Category: | NCP: Voc           | No DO | Α.  | Data                                |                          |  |  |  |

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

| NCR:      |      |                   | WORK ORDI            | ER NON-CONFORMAN             | CE (NCR)    |                        |                       |                         |  |  |  |  |
|-----------|------|-------------------|----------------------|------------------------------|-------------|------------------------|-----------------------|-------------------------|--|--|--|--|
|           | T    | Description of NC |                      | Corrective Action Section B  |             |                        |                       |                         |  |  |  |  |
| DATE      | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval<br>Chief Eng | Approval<br>QC Inspecto |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        | li .                  |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
| · <u></u> |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |
|           |      |                   |                      |                              |             |                        |                       |                         |  |  |  |  |

NOTE: Date & initial all entries



| DART AEROSPACE LTD           | Work Order:  | 38154       |
|------------------------------|--------------|-------------|
| Description: Douly Ell       | Part Number: | D3140-95    |
| Inspection Dwg: \$3(40) Rev: |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Actual Accept Reject Method

| Drawing<br>Dimension | Tolerance | Actual<br>Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|--------|--------|----------------------|----------|
| 6.40<br>3.8(         | 4/- ,030  | 6.40                | ×      |        | ,                    |          |
| 3.8(                 | 7030      | 6.40<br>3.8(        | >4     |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
| -                    |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |
|                      |           |                     |        |        |                      |          |

|              | ,        |             |       |                     |      |
|--------------|----------|-------------|-------|---------------------|------|
| Measured by: | B        | Audited by: | (c)   | Prototype Approval: | 1./2 |
| Date:        | 07-10-19 | Date:       | Alola | Date:               | 10/1 |
|              |          |             |       | <u> </u>            | ·    |

| Pay | 13050 | Change     |            |          |
|-----|-------|------------|------------|----------|
| Hev | Date  | Change     | Revised by | Approved |
| A   |       | New Issue  | noned by   | Approved |
|     | L     | 146W 13506 | KJ/JLM     |          |